

Date: Tuesday, 12/5/2006 8:14:18 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE BLOCK
Job Number : 29770	
Estimate Number : 10324	
P.O. Number : <i>N/A</i>	Part Number : D1049
This Issue : 12/5/2006 S.O. No. : <i>N/A</i>	Drawing Number : D1049 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A
Previous Run : 27073	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 1/15/2007 Qty: 50 Um: Each
Checked & Approved By : <i>[Signature]</i> 06/12/05	
Comment : Est RevC 02.04.10 Re-format NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0750X00250	6061-T6 Bar .750 x .250
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Comment: Qty.: 0.1749 f(s)/Unit Total : 8.7465 f(s)
 Material: 6061-T6 bar .750 wide x .250 thick.
 Batch *M19380*

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut Blanks: 2.000" long

J.L. 06/12/09

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per folio FA217 & Dwg D1049

2-Deburr

J.L. 06/12/10

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L. 06/12/10

5.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

J.L. 06/12/10

GL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ ☐ Date: 27/01/08

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

M.R./J

06/12/21

49

PC

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

FL/Jan

07/01/03

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

PC

7/1/03

49

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *5709*

PC

7/1/03

49

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

01.01.05

Job Completion



4 27.01.05

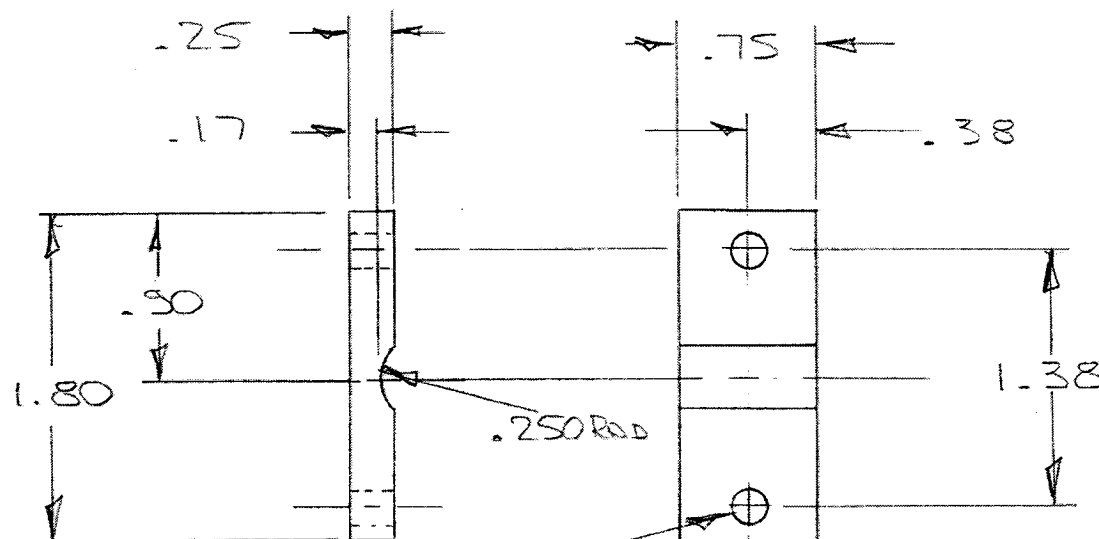
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D1049 PAR #: N/A Fault Category: CWC NCR: Yes No DQA: AA Date: 07.01.05
 QA: N/C Closed: AA Date: 07.01.05

NCR: 29770		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06.12.21	60	1 part found with a deep kink on the side approximately 0.40 deep. R.C. - mat'l handling: strong	<u>[Signature]</u> 06.12.21 05/04/2	Scrap: destroy	<u>[Signature]</u> M.D.	<u>[Signature]</u> 06.12.21	<u>[Signature]</u> 06.12.21 05/04/2	<u>[Signature]</u> 06.12.21

NOTE: Date & initial all entries

RELEASED
97/09/02 BW



.203 DIA.
TYP

MATERIAL : 5052-H32

FINISH : POWDER COAT

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 29770



REVISION		THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.		ITEM		DESCRIPTION		MATERIAL		SPEC/VENDOR	
DRAWN				BASIC CODE		CONTRACT NO.				DATE		DART		DART AERO ACCESSORIES INC. CANADA	
APPROVED				Q=HOLE D=NO OF SHEETS E=COUNTERSINK		LENGTH DASH NO. W=SPOTWELD		DRAWN		1992		DESIGN		1992	
DESCRIPTION		REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES				STRESS				TITLE		SADDLE	
OF		GENERAL		TOLERANCES —		8A=NAS20470AD 8B=NAS20426AD		CHECKED				CODE		D1049	
CHANGE		1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER MIL - 8 - 32/42 5. HOLES PER AND 10087		UNITS 1. TOLERANCES — .001 & .0030 2. ANGLES .001 & .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL H/C CENTRE LINES .005				CLIENT				DWC NO.		REV.	
REPORT ALL DISCREPANCIES — DO NOT SCALE															

